

Title (en)

Anti-corrosion coating with two zinc layers

Title (de)

Korrosionsschutzbeschichtung mit zwei Zinkschichten

Title (fr)

Couche de protection contre la corrosion dotée de deux couches de zinc

Publication

**EP 2157213 B1 20121024 (DE)**

Application

**EP 08014206 A 20080808**

Priority

EP 08014206 A 20080808

Abstract (en)

[origin: EP2157213A1] The method comprises depositing a first zinc layer with a thickness of 15µm in an acid galvanic bath and a second zinc layer with a thickness of 25µm in an alkali galvanic bath. The pH value of the acid bath is 12-14. The treatment duration in the acid galvanic bath is 15 min. The flow density in the acid bath is 0.3 A/dm<sup>2</sup> and the flow density in the alkali bath is 0.5 A/dm<sup>2</sup>. The acid galvanic bath consists of 10-60 g/l of zinc, 80-200 g/l of chloride and 10-40 g/l of boric acid or 5-20 g/l of zinc and 50-200 g/l of sodium hydroxide. The method comprises depositing a first zinc layer with a thickness of 15µm in an acid galvanic bath and a second zinc layer with a thickness of 25µm in an alkali galvanic bath. The pH value of the acid bath is 12-14. The treatment duration in the acid galvanic bath is 15 min. The flow density in the acid bath is 0.3 A/dm<sup>2</sup> and the flow density in the alkali bath is 0.5 A/dm<sup>2</sup>. A thick-coat passivation is deposited directly on the second zinc layer and if necessary a cathodic coating is applied directly on the thick-coat passivation and/or on the second zinc layer.

IPC 8 full level

**C25D 3/22** (2006.01); **C25D 5/10** (2006.01); **C25D 5/48** (2006.01)

CPC (source: EP US)

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